

Work Order ID 87018

87018

Page 1

Item ID: D117-762-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 7/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/07/10* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3582

Rev A

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PRP 9117-762-041 CHG001

120

120

CNC Bend I

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3,
use bending aid DT9632
2- cut fwd end of tube as per dwg

0.00

0.00

DC 12/07/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Start Date: 7/10/2012 Start Qty: 1.00

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1

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Skidtubes

0.00

Skidtubes

Memo

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 *** OPEN AFT CAP HOLE TO .187" ***

4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8900

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

BE 12/08/01

BE 12/08/01

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

1-Weld fwd cap D2964 per dwg D3582 and QSI 004
A/R AL ROD Batch: M122324
2-Grind flush*3 BE 12/08/02*

150

QC10- Inspect visual per QSI004- ground welds

0.00

150

QC

Memo

0.00

Quality Control

*DAF
9-11-03
12/08/03*

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

*DAF
9-11-03
12/08/03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 7/24/2012 Req'd Qty: 1.00

1

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

1 76 12-8-7

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

Pb-7

W/O: 87018		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See Pink 12-1754

Signature Aluminium

Part No: P117-762-041 PAR #: _____ Fault Category: Scraps NCR: Yes No DQA: OK Date: 12/08/30

Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 957.49						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/07	12	Found Duesin Alpin that A large score was on the Bottom of the tube. due to mis handling	DAS 12/8/07 12/14/22	SCRAP + Destroy No Repair	SAD 12-08-07	DAS 16 12/08/07	DAS 16 12/14/22	DAS 16 12/08/07

NOTE: Date & initial all entries

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Start Date: 7/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

0.00

190

Skidtubes

0.00

Skidtubes

Memo

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: _____
Exp Date: _____

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: _____

6-Grind welds flush

200

QC10- Inspect visual per QSI004- ground welds

0.00

200

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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1

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Required Date: 7/24/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

210

QC

Memo

0.00

Quality Control

215

Pressure Wash per QSI005 4.3

0.00

215

HandFinish

Memo

0.00

Hand Finishing

Touch-up alodine as per QSI

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Memo

0.00

Powder Coating

START TIME _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 7/10/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

250

HandFinishing

0.00

250

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: _____
Exp Date: _____

3-Install Wearplates as per Dwg D3582,

Note: Install Bolt and washer on Ground Wire inserts on top of tube see
section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: _____
Exp Date: _____

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: _____

5- Wing Walk as per Dwg D3582 and QSI 005 4.4

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 7/10/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00

260

QC

Memo

0.00

Quality Control

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D117-762-041

Location: _____

PPP Rev: _____

280

QC21- Final Inspection - Work Order Release

0.00

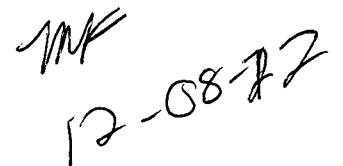
280

QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 1

Work Order ID: 87018

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.06.11New Issue EC
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-11 Plug		Manufactured	No			250	Each	30.0000	2	2			

Location	Loc Qty	Loc Code
FP002	10	
71863	2	
74732	8	
FP-A	20	
82253	20	

D3492-13 Plug		Manufactured	No			250	Each	38.0000	6	6			
------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
FP001	20	
83518	20	
FP-A	18	
80322	18	

D3492-9 Plug		Manufactured	No			250	Each	38.0000	2	2			
-----------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
FP002	1	
46694	1	
FP-A	37	
80323	17	
82251	20	

D2962-150 3.540 Outer Tube, Extrud		Manufactured	No				Each	28.0000					
---------------------------------------	--	--------------	----	--	--	--	------	---------	--	--	--	--	--

Location	Loc Qty	Loc Code
HALL	28	
59934	28	

DC 12¹/07/31

①

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID: 87018

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D2964 Manufactured No 140 Each 29.0000 1 1

Cap

BE 12/08/02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	12	
83064	12	
LG002	17	
74719	17	

D2971 Manufactured No 190 Each 22.0000 1 1

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	22	
74720	22	

D3584-1 Manufactured No 190 Each 4.0000 1 1

Web

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	4	
80849	4	

D2973 Manufactured No 190 Each 64.0000 2 2

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	64	
14636	14	
80092	50	

D3662-3 Manufactured No 190 Each 57.0000 1 1

Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	57	
81606	57	

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Parent Item Name: Replacement Skidtube

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3662-1
Crossbolt Spacer

Manufactured No

190 Each 63.0000 3 3

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	61	
81607	61	
LG001	2	
71799	1	
71857	1	

ALS4-1032-130
Insert

Purchased No

Each 1,209.0000 36

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	205	
119084	116	
120671	89	
ST281	44	
120807	36	
120837	8	
ST282	960	
121269	960	

ALS4-428-165
Inserts

Purchased No

Each 437.0000 2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	437	
114172	18	
117769	419	

D2965
Cap, 105 Skidtube

Manufactured No

250 Each 44.0000 1 1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	44	
71371	4	
80089	40	

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Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3508-3	Manufactured	No	250	Each	6.0000	1	1
Wearplate							
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		FP001	6				
		38527	1				
		81347	5				
D3598-9	Manufactured	No	250	Each	10.0000	1	1
Wearplate							
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		FP001	10				
		81346	10				
D3558-3	Manufactured	No	250	Each	6.0000	1	1
Gasket							
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		FP	5				
		82312	5				
		FP002	1				
		71651	1				
D3558-9	Manufactured	No	250	Each	8.0000	1	1
Gasket							
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		FP002	8				
		80340	8				
D3558-11	Manufactured	No	250	Each	9.0000	1	1
Gasket							
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		FP002	9				
		80339	9				

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Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3558-13	Manufactured	No	250	Each	40.0000	1	1
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	12	
82320	12	
FP002	28	
59558	1	
82380	27	

D3508-11	Manufactured	No	250	Each	24.0000	1	1
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	24	
81345	12	
81349	12	

D3508-13	Manufactured	No	250	Each	15.0000	1	1
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	3	
71794	3	
FP002	12	
81348	12	

AN960JD10L	NAS1149D0332J	Purchased	No	250	Each	0.0000	2	2
Washer								

AN3C4A		Purchased	No	250	Each	3,858.0000	28	28
BOLT								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	3858	
120187	31	
120521	28	
120769	38	
121205	67	
121556	8	
122151	3686	

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 87018

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A	Purchased	No	250	Each	1,611.0000	2	2
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	7	
115835	7	
ST350	1604	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	28	
121255	469	
121444	34	
121708	500	
122141	500	

AN960JD416L	NAS1149D0416J	Purchased	No	250	Each	6.0000	2	2
Washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	6	
110153	6	

AN960C10L	NAS1149C0332R	Purchased	No	250	Each	21.0000	28	28
washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	21	
107534	21	

AN4-4A	Purchased	No	250	Each	50.0000	2	2
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	6	
114615	6	
ST355	44	
120187	31	
121285	13	

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Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 09, 2012 4:03:40 PM

Page 7

Work Order ID: 87018

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-012

Purchased

No

250

Each

126.0000

6

6

O-RING

Location

Loc Qty

Loc Code

FP

14

120820

14

FP001

112

113845

10

118384

2

121259

100

NAS1611-015

Purchased

No

250

Each

103.0000

2

2

O-RING

Location

Loc Qty

Loc Code

FP001

103

115101

85

116081

18

NAS1611-016

Purchased

No

250

Each

56.0000

2

2

O-RING

Location

Loc Qty

Loc Code

FP001

56

112492

42

113524

14

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

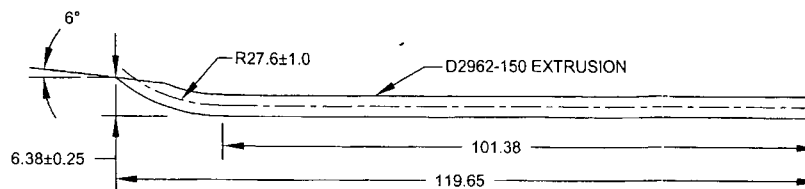
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

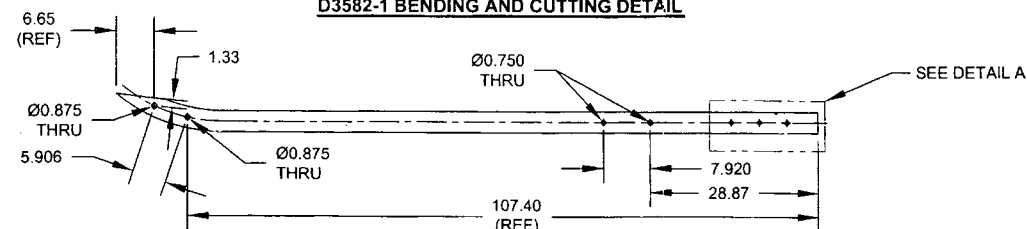
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

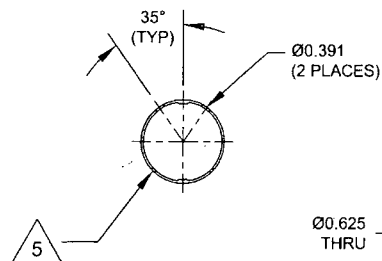
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4.



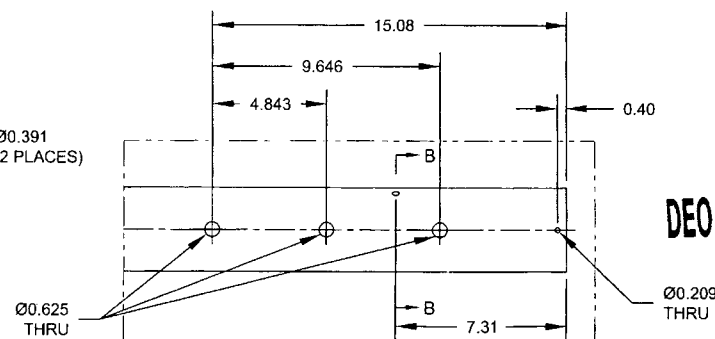
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5



DETAIL A
SCALE 1:5

RELEASED
07-11-22

REV.	DESCRIPTION	PH	07.06.08
DESIGN		BY	DATE
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.06.08		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D2964 CAP
(GRIND FLUSH)

DETAIL C
SCALE 1:10

D2971 SPACER

AFTER FINISH
INSTALL
D3492-049
PLUG ASSEMBLY
(2 PLACES)

SECTION D-D
SCALE 3:10

AFTER FINISH
INSTALL
D3492-051
PLUG ASSEMBLY
(2 PLACES)

SECTION E-E
SCALE 3:10

D3662-3 SPACER

SECTION D-D NOTES

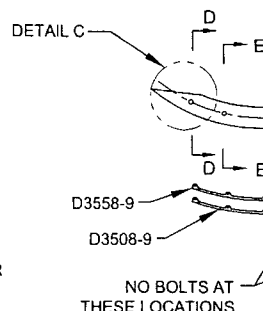
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2971 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-049 PLUG ASSEMBLY (2 PLACES)

SECTION E-E NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-051 PLUG ASSEMBLY (2 PLACES)



D3582-041 ASSEMBLY DETAIL

BLACK ANTI-SKID

BLACK ANTI-SKID (TYP)

D3582-041 BLACK ANTI-SKID DETAIL

DEO ATTACHED

D2973 SPACER
(2 PLACES)

SECTION F-F
SCALE 3:10

SECTION F-F NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2973 SPACER (2 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.625 DRILL TO REMOVE SPILL OVER

D3584-1 WEB (REF)

D3662-1 SPACER
(3 PLACES)

AFTER FINISH, INSTALL
AELS-1032-130
INSERT (36 PLACES)

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(28 PLACES)

SECTION G-G
SCALE 3:10

SECTION G-G NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-053 PLUG ASSEMBLY (6 PLACES)

AFTER FINISH, INSTALL
ALS7-428-165 INSERT (1)
AN4-4A BOLT (1)
AN960JD416L WASHER (1)
(2 PLACES)

AFTER FINISH
INSTALL
D3492-053
PLUG ASSEMBLY
(6 PLACES)

D3584-1 WEB
(REF)

AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

DETAIL H
SCALE 1:5

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3582	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

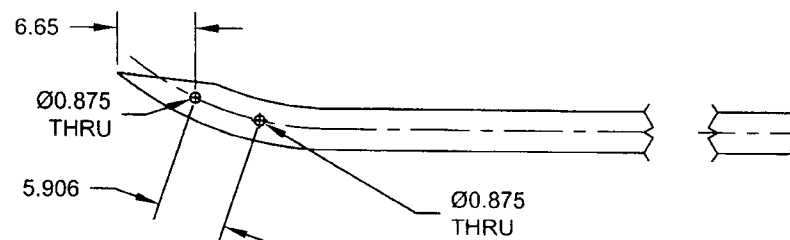
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

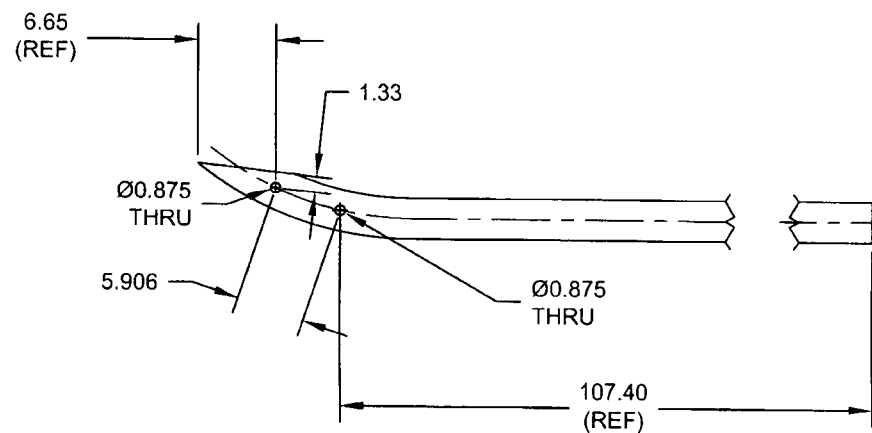
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>B</i>	MFG. APPR. <i>B</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 09/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



RELEASED
09/04/22 *MD*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

